

Work Order ID 162146

Monday, May 29, 2017 8:38:12 AM

162146

Page 1

Item ID: D5370-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Fitting

Start Date: 5/29/2017 Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/29/2017 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: MAY 29 2017

Run Start

NR1QC: 9-89

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D5370

A

100

0.00

100

Lathe Conv

Conventional Lathe

Memo

TURN AS PER DWG
DWG REV: A

2.45

DEBURR

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.12

DAS

32

9-89

17-06-16

DAS

32

9-89

17-06-16

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

DQA: _____ Date: _____



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Monday, May 29, 2017 8:38:12 AM

162146

Page 3

Item ID: D5370-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Fitting

Start Date: 5/29/2017 Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/29/2017 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location SH166

0.00

130

Packaging

Memo

0.12

Packaging

12

DAS

6

9-89

JUN 21 2017

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

1.20

Quality Control

17/6/27

DAS
21
9-89

JUN 22 2017

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Monday, May 29, 2017 8:38:15 AM

Page 1

Work Order ID: 162146

162146

Parent Item: D5370-1

D5370-1

Parent Item Name: Fitting

Start Date: 5/29/2017

Required Date: 5/29/2017

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 16-02-01 VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN919-6J		Purchased	No			100	Each	6.0000	1	12			
----------	--	-----------	----	--	--	-----	------	--------	---	----	--	--	--

AN919-6.J

Reducer

**

10X DAI 37710
17-06-15

DAC

32

9-88

Location

Loc Qty

Loc Code

ST323

6

m134070

4

m135864

2

m 137 710

2
10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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DQA: _____ Date: _____

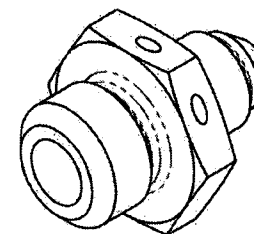
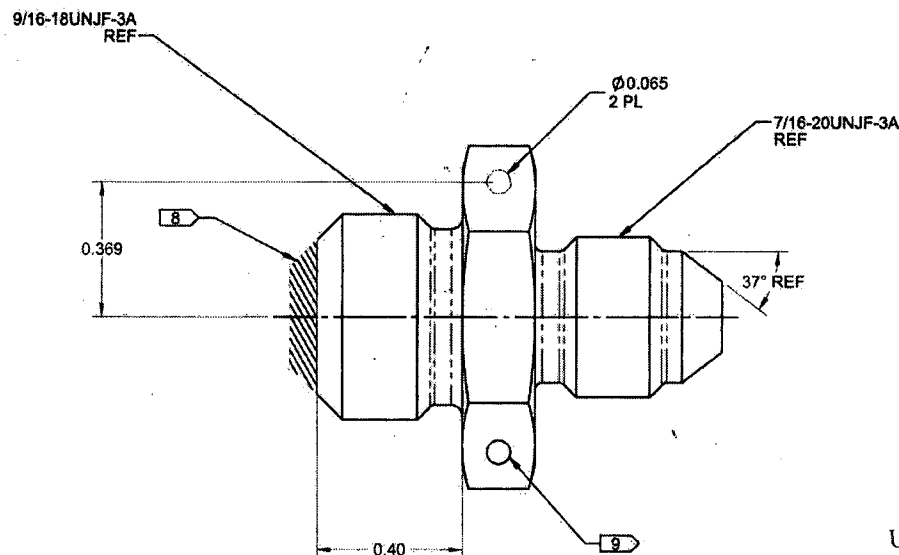
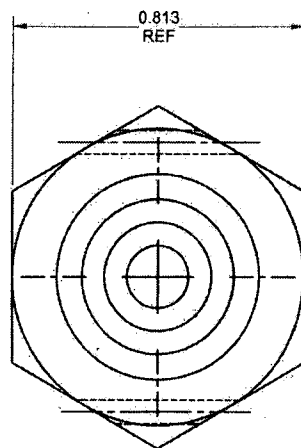


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Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



D5370-1 FITTING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 16246 MGS
12-05-29

NOTES:

- 1) MATERIAL: MAKE FROM AN919-6J OR AN919-6K
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.7
- 7) WEIGHT: 0.08 lbs
- 8) REMOVE MATERIAL FROM END TO ACHIEVE THE DIMENSIONS SHOWN
- 9) LOCKWIRE HOLES SHALL BE CENTRED ON HEX

RELEASED
2016-10-05
ECN 16-588

APPROVED

A NEW ISSUE		CC	16.01.07
REV.	DESCRIPTION	BY	DATE
DESIGN	CC		
DRAWN	CC		
CHECKED	AK		
MFG. APPR.	JLM		
APPROVED	HS		
DE APPR.	DS		
DATE	16.01.07		

DART AEROSPACE USA INC
EUGENE, OREGON, USA

DRAWING NO.
D5370

TITLE
FITTING

REV. A
SHEET 1 OF 1
SCALE
NTS

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